

Date: Friday, 23/03/2007 8:25:48 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARM
<b>Job Number</b> : 31447	
<b>Estimate Number</b> : 12590	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D35604
<b>This Issue</b> : 23/03/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3560 <i>UNDER REVIEW</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 30867	<b>Material</b> : N/A
<b>Written By</b> :	<b>Due Date</b> : 26/03/2007 <b>Qty:</b> 3 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev: A New Issue 06-11-10 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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**Comment:** Qty.: 0.7350 f(s)/Unit Total: 2.2050 f(s) *2.9400*

6061-T6 Bar .50" x 6.0"

Batch: *ML10A19**ml 07 03 23*

(4)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: *A*Prog Rev: *A**ml 07 03 23*

(4)

2-Deburr if necessary

Note: .507" Dia &amp; .196" Dia Holes are to opened on manual mill after Waterjet

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*ml 07 03 23*

(4)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560

\*\*\*Ensure to C'Bore on Corect side\*\*\*

*MS 07103123*

(4)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 31447

Part Number: D35604

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/03/26 (4)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/03/26 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

J.F. 07.03.26 4

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

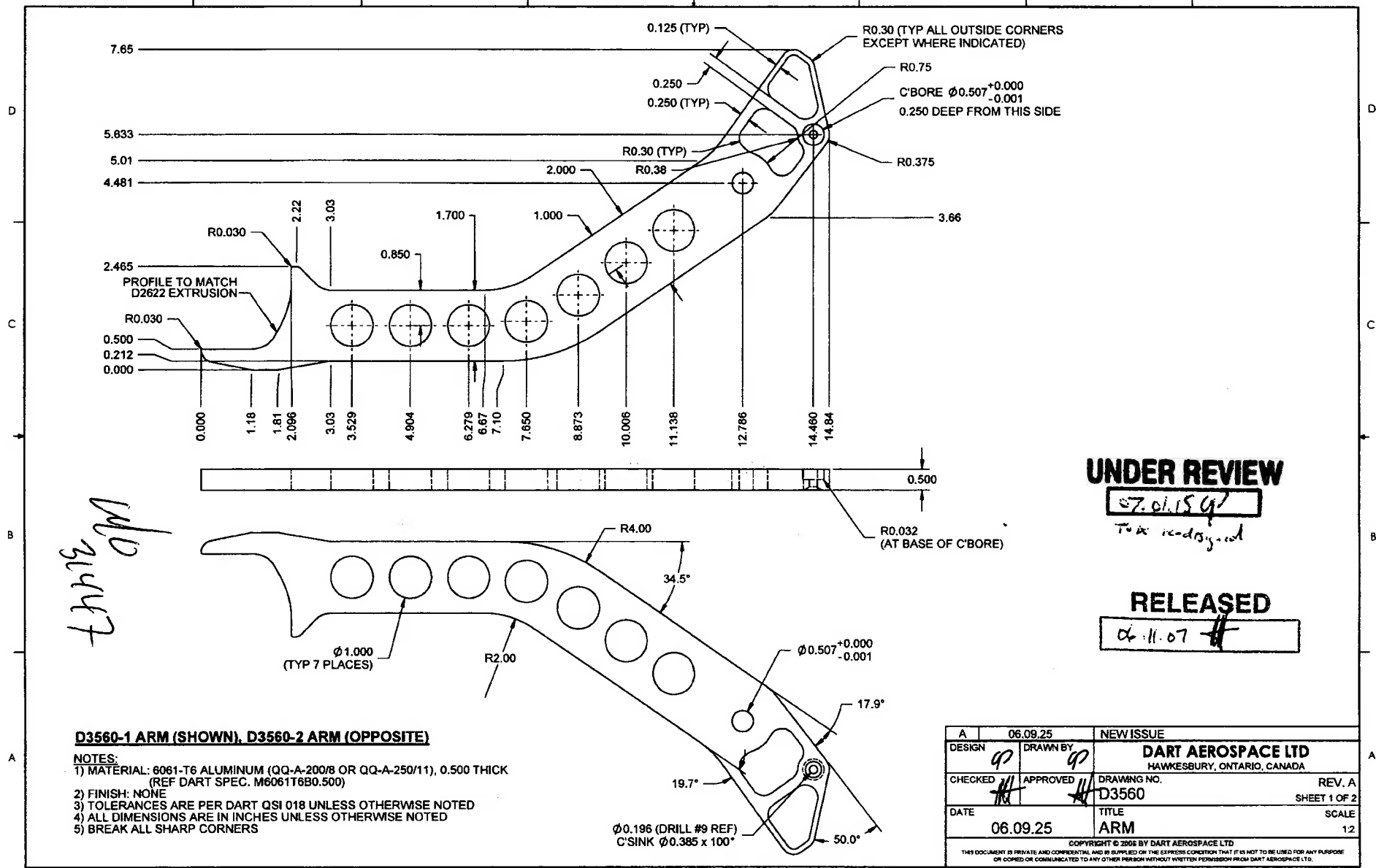
(4)  
J.F. 07/03/26

Job Completion



U 07.03.26

8 7 6 5 4 3 2 1



**UNDER REVIEW**

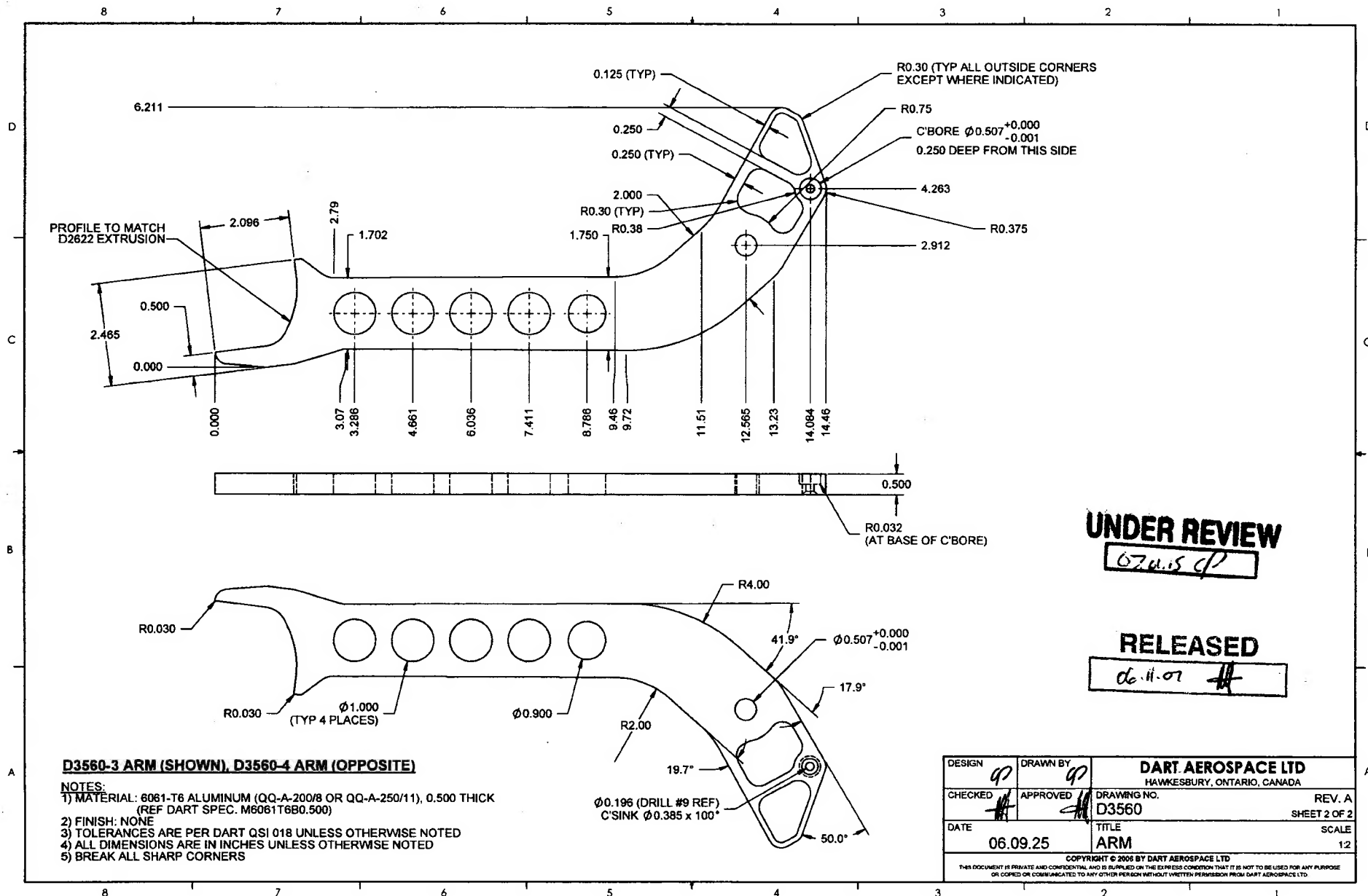
07.01.15 9/

To be re-designed

**RELEASED**

06.11.07

*thru 06/09/25*



**UNDER REVIEW**

07.01.07

**RELEASED**

06.11.07

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	06.09.25	DRAWING NO.	REV. A
		D3560	SHEET 2 OF 2
		TITLE	SCALE
		ARM	1:2

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31447
<b>Description:</b> ARM		<b>Part Number:</b> D3560-4
<b>Inspection Dwg:</b> 3560 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 1.000	+0.012-0.001	1.003	✓		vern	
B	Ø 0.900	+0.010-0.001	0.902	✓		vern	
C	Ø 0.507	+0.008-0.001	0.507	✓		vern	
D	Ø 0.196	+0.005-0.001	0.201	✓		vern	
E	0.500	+/- 0.010	0.500	✓		vern	
F	0.250	+/- 0.010	0.252	✓		vern	
G	0.125	+/- 0.010	0.126	✓		vern	
H	0.250	+/- 0.010	0.250	✓		vern	
I	2.000	+/- 0.010	2.002	✓		vern	
J	1.750	+/- 0.010	1.748	✓		vern	
K	2.465	+/- 0.010	2.465	✓		vern	
L	1.702	"	1.704	✓		vern	
M	.507	+ .000 - .001	.507	✓			
N	.385 x 1000	± .010	.385	✓			
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b> M. M	<b>Audited by:</b>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07 03 23	<b>Date:</b>	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
		New Issue	KJ/RF	